

Date: Thursday, 8/30/2007 3:49:31 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: CAP	
Job Number	34349				
Estimate Number	10519				
P.O. Number	N/A		Part Number	: D2855	
This Issue	8/30/2007	S.O. No.	Drawing Number	: D2855 REV. A	
Prsht Rev.	NC		Project Number	: N/A	
First Issue	N/A	Type	Drawing Revision	: A	
Previous Run	30279		Material	: N/A	
Written By			Due Date	: 9/30/2007	
Checked & Approved By			Qty:	30	Um: Each
Comment	Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: 4509 <i>20/08/31</i> Cast per Dwg D2855 Material Release Note Required		
2.0	D2855P	Cap
Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) CAP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
<i>20/09/10/30</i> Comment: DIMENSIONAL CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr		
		<i>FF 07-10-18 30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 34349

Part Number: D2855

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5



INSPECT WORK TO CURRENT STEP

counts

Comment: INSPECT WORK TO CURRENT STEP

5/2/10/18 (X30)

7.0 POWDER COATING

POWDER COATING



M105068



Box

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m/l 07/10/22

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MA



Comment: INSPECT POWDER COAT

07-10-22

30X

9.0 ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

m/10621

FL 30

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

10.0 SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

FL 07/10/22 (30)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts  
5/10/22 (X30)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-14

FL 07/10/22 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes Yes No No DQA: D Date: 07/10/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:49:31 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 34349

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



34

Comment: FINAL INSPECTION/W/O RELEASE

207/10/23

Job Completion



U 8/10/23

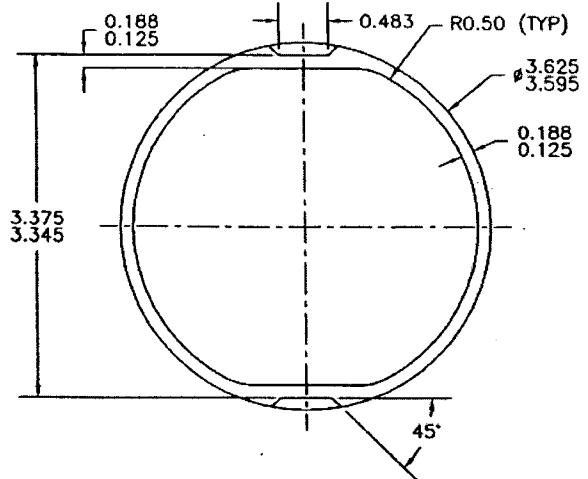
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

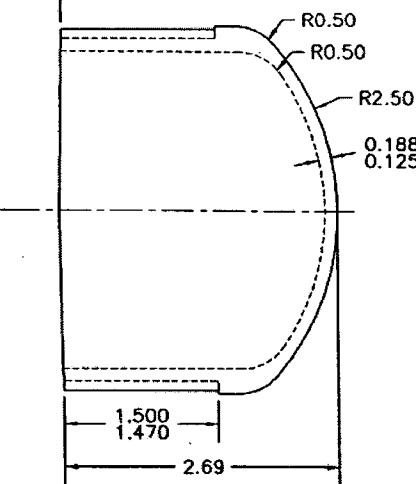
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

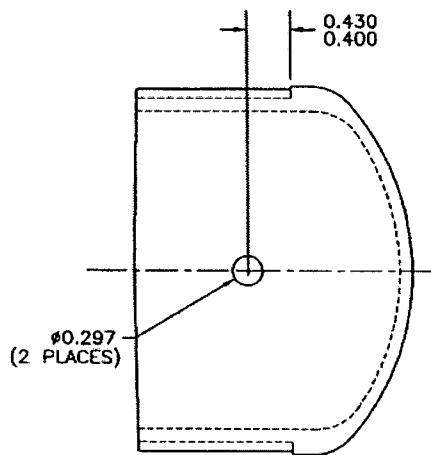
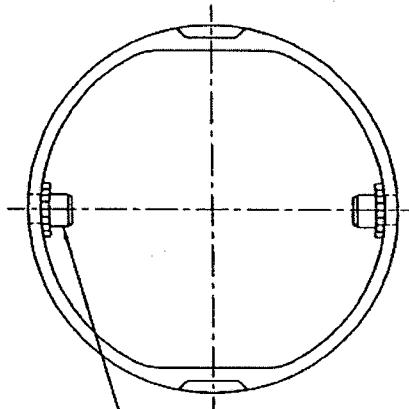
D2855 CASTING DETAIL



1° TAPER



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP (AFTER POWDER COAT) (2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

**RELEASED**  
98.12.14 DS

**DART**

© COPY 98  
DART

DESIGN <i>MM</i>	DRAWN BY <i>MM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>GP</i>	APPROVED <i>KE</i>	DRAWING NO. D2855	SCALE N/A	REV. A SHEET 1 OF 1
DATE 98.12.12		TITLE CAP		
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)		

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER 34329  
NO.

# Aluminum Foundry Ltd

714-716 Calais  
Dorval, Québec H9P 2P3  
Tel: (514) 631-1331  
Fax: (514) 631-8448  
email: info@foundryafpw.com

# Packing Slip

Packing Slip No.: 32147  
Shipped Date: Sep 07, 2007

Sold to:	Ship to:
<p><b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7</p>	<p><b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7</p>
Tel. (613) 632-3336 Fax (613) 632-4443	
Order No.: 4509	
Shipper By: PUROLATOR	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	30

*SP 07/09/10*

Received by:

Date:

Comment:

CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTÉE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à  
Shipped.

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing Date: 07/09/2007 Slip No. 32147

Hawksbury, ON, K6A 1K7

Votre No. Commande 4509  
Your order No. 4509

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications Specifications	Note d'Ingrédient Incoming ingredient Note
30	D 2855 CAP	Z098046	A356.2	Ingot 348

Analyse  
Analysis (as in Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.44%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne Yield : Résistance à la tension :  
Tensile Strength :

Allongement par pouce carré :  
P.S.I. Elongation : %

Pour et au nom de  
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTÉE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :  
Par/Per : 

Coc-100

**Purchase Order**

Date Aug 31, 2007	Page 1
Purchase Order Number PO00004509	01

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

*REVISED**FAXED*  
*08/09/07***Vendor Address:**

Aluminum Foundry & Pattern Works (1988)  
714-716 Calais  
Dorval, QC H9P 2P3  
Phone (514) 631-1331  
Fax (514) 631-8448

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-ALU001	Aug 31, 2007	N30	Purolator	Sep 21, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
30.0000	D2855P	Cap Comments: AS PER DWG D2855 REV. A MATERIAL: CAST ALUMINUM ALLOY A356.2	9/21/2007	No	<i>10.00</i>	Each	<i>300.00</i>

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

Comments:	Tax Summary: GST GSTME GSTND	Less: included tax Subtotal Total tax Total purchase order in CAD Dollars	  

Entered By: *CLAVOIE*Approved By: *✓*

10

1

1

1

# DART

## Purchase Order

**FAXED**  
*Claire B*

Date	Page
Aug 31, 2007	1
Purchase Order Number	PO00004509

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**Vendor Address:**  
Aluminum Foundry & Pattern Works (1988)  
714-716 Calais  
Dorval, QC H9P 2P3  
Phone (514) 631-1331  
Fax (514) 631-8448

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-ALU001	Aug 31, 2007	N30	Purolator	Sep 21, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
30.0000	D2855P	Cap	9/21/2007	No	██████████	Each	██████████

**Comments:** AS PER DWG D2855 REV. A  
MATERIAL: CAST ALUMINUM ALLOY A356.2

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

*✓  
Claire B*

Comments:

Tax Summary:  
GST  
GSTME  
GSTND

Entered By: *CL* CLAVOIE  
Approved By: *CL*

Less:  
included tax

Subtotal

Total tax

Total purchase order in  
CAD Dollars

